



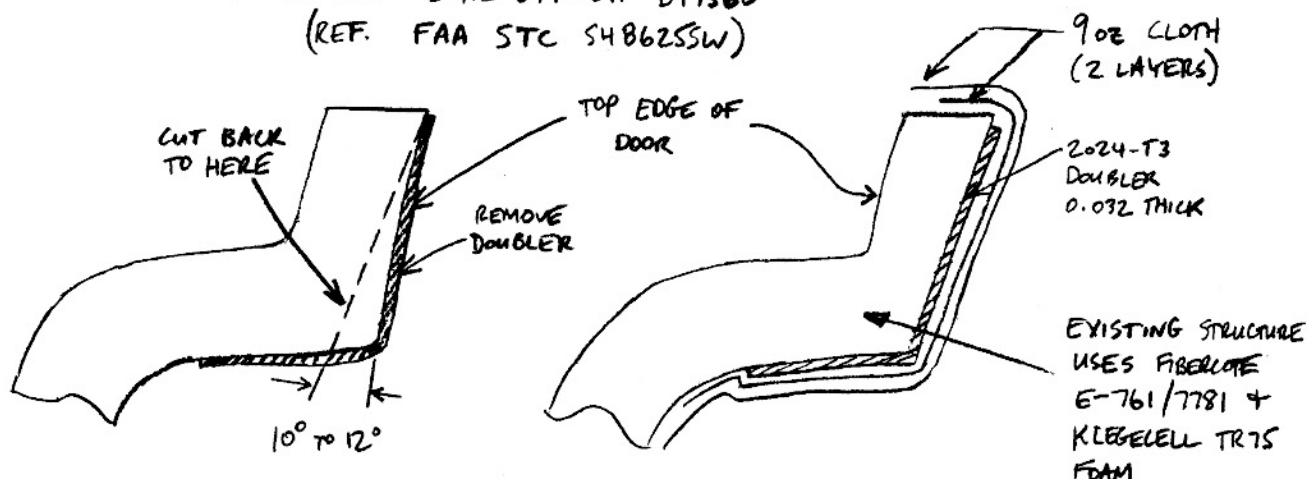


DART

DESIGN 	DRAWN BY 	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. DSI 9259	REV. A SHEET 1 OF 1
DATE 03.04.07	TITLE SPACEDoor REPAIR		SCALE NTS
A	03.04.07	NEW ISSUE	

DART SERVICE INSTRUCTION

TO REPAIR D412-694-011 B17560
(REF. FAA STC 54862SSW)



TO IMPROVE FIT OF D412-694-011 SPACEDOORS & ALLEVIATE INTERFERENCE WITH ENGINE COWLING:

1. REMOVE EXISTING 80-005-2-8 INSERTS AND DOUBLERS ALONG TOP EDGE OF DOOR.
2. CUT BACK FOAM 10° TO 12° TO MATCH CONTOUR OF REGULAR DOORS.
3. RE-INSTALL DOUBLERS USING METALSET A4 OR MAGNABOND 639B
4. LAYUP 2 PLIES OF 9oz "S" GLASS UNIVERSAL WEAVE USING EPOCAST SD-A/9816 OR HYSOL EA 936 A+B / 9309.3NA/9330/9330.3/9359.3 AS SHOWN ABOVE. OVERLAP LAYERS OF 9oz. AS SHOWN.
5. SMOOTH REPAIRED AREA.
6. DEEPEN CAVITIES FOR INSTALLATION OF 80-005-2-8 INSERTS. INSTALL INSERTS USING HYSOL EA 934 ADHESIVE OR MAGNABOND 639B
7. TOUCH UP PRIMER FINISH USING DUPONT GLET HIGHBUILD PRIMER 1144-S
8. REPLACE D3109-041/-042 (B30-23000-109/-110) WITH D3183-041/-042

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